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K6A 1K7
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Nov

D350-591-311
Job Sheet 198861



Part No: D350-591-311

Job Qty: 5 pcs

Part Name: Heli-Access-Step™ LH - High Gear, Long Step, Aerazur Float Compatible



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 8/7/19

Job Tracking No:

Due Date: 11/5/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV B IPP Rev:A 04.03.22 New issue KJ/RF IPP Rev:B 07-06-09 Added D3272-1 JLM IPP C returned to CHG001 for Eurocopter, ref NCR08-082 LL verified by:EC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
110	Large Fab - Steps - 1	5 pcs	11/5/19		0.00	4.96	Large Fab - 1		<i>5/6</i>
							Large Fab - 10		
							Large Fab - 2		
							Large Fab - 3		
							Large Fab - 4		
							Large Fab - 5		
							Large Fab - 6		
							Large Fab - 7		
							Large Fab - 8		
							Large Fab - 9		
							Large Fab - 11 (Various)		
120	QC 9	5 pcs	11/5/19		0.00	0.00	QC 9 - 10		DAS 24 9-89
							QC 9 - 18		
							QC 9 - 24		
							QC 9 - 43		
							QC 9 - 50		
							QC 9 - 9		
130	QC 5	5 pcs	11/5/19		0.00	0.00	QC 5 - 10		DAS 24 9-89
							QC 5 - 12		
							QC 5 - 17		
							QC 5 - 18		
							QC 5 - 19		
							QC 5 - 22		
							QC 5 - 24		
							QC 5 - 3		
							QC 5 - 43		
							QC 5 - 49		
							QC 5 - 51		
							QC 5 - 58		
							QC 5 - 68		

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					QC 5 - 9	
					QC 5 - 50	
					QC 5 - 30	
					QC 5 - 40	
					QC 5 - 61	
					QC 5 - 81	
					Handfinish - 1 - 1 - B4B	
					Handfinish - 1 - 2 - B4B	
					Handfinish - 1 - 3 - B4B	
					Handfinish - 1 - 4 - B4B	
140 Handfinish - 1-1 Chemical-B4B	5 pcs	11/5/19	0.00	0.92	Handfinish - 1 - 5 - B4B	
					Handfinish - 1 - 6 - B4B	
					Handfinish - 1 - 7 - B4B	
					Handfinish - 1 - 8 - B4B	
					Handfinish - 1 - 9 - B4B	
					Handfinish - 1 - 10 - B4B	
					Handfinish - 1 - 11 - B4B	
					Handfinish - 1 - 12 - B4B	
					Handfinish - 1 - 13 - B4B	
					Handfinish - 1 - 14 - B4B	
					Handfinish - 1 - 15 - B4B	
					Handfinish - 1 - 16 - B4B	
					Handfinish - 1 - 17 - B4B	
					Handfinish - 1 - 18 - B4B	
					Handfinish - 1 - 19 - B4B	
					Handfinish - 1 - 20 - B4B	
					Handfinish - 1 - 21 - B4B	
					Handfinish - 1 - 22 - B4B	
150 QC 7	5 pcs	11/5/19	0.00	0.00	QC 7 - 10	
					QC 7 - 13	
					QC 7 - 14	
					QC 7 - 15	
					QC 7 - 17	
					QC 7 - 18	
					QC 7 - 19	
					QC 7 - 2	
					QC 7 - 28	
					QC 7 - 3	
					QC 7 - 30	
					QC 7 - 34	
					QC 7 - 36	
					QC 7 - 37	
					QC 7 - 41	
					QC 7 - 47	
					QC 7 - 48	
					QC 7 - 51	
					QC 7 - 58	
					QC 7 - 59	
					QC 7 - 60	
					QC 7 - 9	
					QC 7 - 68	
					QC 7 - 50	
					QC 7 - 67	
					QC 7 - 40	
					QC 7 - 24	
					QC 7 - 43	
					QC 7 - 61	
					QC 7 - 81	
180 Large Fab - Steps - 2 - B4B	5	11/5/19	0.00	4.96	Large Fab - 1 - B4B	

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JAS
81
9-89

8/7/2019

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				pcs		Large Fab - 10 - B4B	
						Large Fab - 2 - B4B	
						Large Fab - 3 - B4B	
						Large Fab - 4 - B4B	
						Large Fab - 5 - B4B	
						Large Fab - 6 - B4B	
						Large Fab - 7 - B4B	
						Large Fab - 8 - B4B	
						Large Fab - 9 - B4B	
						Large Fab - 11 - B4B (Various)	
190	QC 10	5	11/5/19	0.00 0.00		QC 10 - 10	
				pcs		QC 10 - 18	
						QC 10 - 24	
						QC 10 - 43	
						QC 10 - 50	
						QC 10 - 58	
						QC 10 - 9	
200	QC 5	5	11/5/19	0.00 0.00		QC 5 - 10	
				pcs		QC 5 - 12	
						QC 5 - 17	
						QC 5 - 18	
						QC 5 - 19	
						QC 5 - 22	
						QC 5 - 24	
						QC 5 - 3	
						QC 5 - 43	
						QC 5 - 49	
						QC 5 - 51	
						QC 5 - 58	
						QC 5 - 68	
						QC 5 - 9	
						QC 5 - 50	
						QC 5 - 30	
						QC 5 - 40	
						QC 5 - 61	
						QC 5 - 81	
210	Handfinish - 1-2- Chemical- B4B	5	11/5/19	0.00 0.92		Handfinish - 1 - 1 - B4B	
				pcs		Handfinish - 1 - 2 - B4B	
						Handfinish - 1 - 3 - B4B	
						Handfinish - 1 - 4 - B4B	
						Handfinish - 1 - 5 - B4B	
						Handfinish - 1 - 6 - B4B	
						Handfinish - 1 - 7 - B4B	
						Handfinish - 1 - 8 - B4B	
						Handfinish - 1 - 9 - B4B	
						Handfinish - 1 - 10 - B4B	
						Handfinish - 1 - 11 - B4B	
						Handfinish - 1 - 12 - B4B	
						Handfinish - 1 - 13 - B4B	
						Handfinish - 1 - 14 - B4B	
						Handfinish - 1 - 15 - B4B	
						Handfinish - 1 - 16 - B4B	
						Handfinish - 1 - 17 - B4B	
						Handfinish - 1 - 18 - B4B	
						Handfinish - 1 - 19 - B4B	
						Handfinish - 1 - 20 - B4B	
						Handfinish - 1 - 21 - B4B	
						Handfinish - 1 - 22 - B4B	

OCT 21 2019
DAS 68
9-89

OCT 21 2019
DAS 68
9-89

OCT 22 2019

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220 Powdercoat - 1 White GI(A)- B4B	5 pcs	11/5/19	0.00 1.45	Powdercoat - 1 - B4B	
				Powdercoat - 2 - B4B	
				Powdercoat - 3 - B4B	
				Powdercoat - 4 - B4B	
				Handfinish - 3 - 1 - B4B	
230 Handfinish - 3-1- WingWalk- B4B	5 pcs	11/5/19	0.00 0.92	Handfinish - 3 - 2 - B4B	
				Handfinish - 3 - 3 - B4B	
				Handfinish - 3 - 4 - B4B	
				Handfinish - 3 - 5 - B4B	
				QC 3 - 10	
240 QC 3	5 pcs	11/5/19	0.00 0.00	QC 3 - 13	
				QC 3 - 15	
				QC 3 - 17	
				QC 3 - 18	
				QC 3 - 2	
				QC 3 - 28	
				QC 3 - 3	
				QC 3 - 30	
				QC 3 - 34	
				QC 3 - 36	
				QC 3 - 41	
				QC 3 - 51	
				QC 3 - 58	
				QC 3 - 59	
				QC 3 - 68	
				QC 3 - 9	
				QC 3 - 40	
				QC 3 - 19	
				QC 3 - 43	
				QC 3 - 24	
				QC 3 - 61	
				QC 3 - 81	
250 Packaging 1-1 - Pick Kit - B4B	5 pcs	11/5/19	0.00 0.00	Packaging 1 - 1 - B4B	
				Packaging 1 - 2 - B4B	
				Packaging 1 - 3 - B4B	
				Packaging 1 - 4 - B4B	
				Packaging 1 - 5 - B4B	
				Packaging 1 - 6 - B4B	
				Packaging 1 - 7 - B4B	
				Packaging 1 - 8 - B4B	
				Packaging 1 - 9 - B4B	
				Packaging 1 - 10 - B4B	
				Packaging 1 - 11 - B4B	
				Packaging 1 - 12 - B4B	
				Packaging 1 - 13 - B4B	
				Packaging 1 - 14 - B4B	
				Packaging 1 - 15 - B4B	
				Packaging 1 - 16 - B4B	
				Packaging 1 - 17 - B4B	
				Packaging 1 - 18 - B4B	
				Packaging 1 - 19 - B4B	
				Packaging 1 - 20 - B4B	
				Packaging 1 - 21 - B4B	
				Packaging 1 - 22 - B4B	
				Packaging 1 - 23 - B4B	
				Packaging 1 - 24 - B4B	
				Packaging 1 - 25 - B4B	
				Packaging 1 - 26 - B4B	
				Packaging 1 - 27 - B4B	

BK 19-10-22

NL 19-10-22

DAS
OCT 30 2019 68
g.m.

NL 8/11/19

Part Op 110 - (Weld per dwg A/R Aluminum rod Batch: _____) 1-Bevel end for welding FWD ONLY 2-Weld Support using Jig
 Descriptions: DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272 A/R Aluminum Rod _____ 3-Grind End Plate flush
 120 - (QC9- Inspect visual per QSI004- Fusion Welds)
 130 - (QC5- Inspect part completeness to step on W/O)
 140 - (Chemical Conversion Coat per QSI005 4.1)
 150 - (QC7-Inspect Chemical Conversion Coat)
 180 - (Weld per dwg A/R Aluminum rod Batch: _____) 1-Assemble Leg Assembly as per Dwg D3272. 2-Leave one rivet
 out until welding is complete. 3-Bevel Aft end for welding 4-Inspect for foreign object as per QSI 024 5-Weld Aft End Plate
 as per QSI 004 & Dwg D3272 A/R Aluminum Rod _____ 6-Grind End Plate flush 7-Install last rivet as per Dwg.
 190 - (QC10- Inspect visual per QSI004- ground welds)
 200 - (QC5- Inspect part completeness to step on W/O)
 210 - (Chemical Conversion Coat per QSI005 4.1)
 220 - (White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum) START TIME: _____ OVEN TEMPERATURE: _____
 FINISH TIME: _____
 230 - (Wing Walk as per dwg QSI005 4.4 Batch _____)
 240 - (QC3- Inspect Part Finish)
 250 - (Pick Kit)
 260 - (QC4- 100% Inspect kits for completeness)
 270 - (Identify as per dwg & Stock Location: _____) Identify and pack for shipping as per PPPD350-591-311 Location :
 FG109
 275 - (Document Control) Photocopy bluefile and type labels as per PPP D350-591-311 CHG001
 280 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3087-1	End Plate	10 pcs (2 ea)	110-Large Fab - Steps - 1	S220700
D3219-1	Plate	10 pcs (2 ea)	110-Large Fab - Steps - 1	S207055
D3272-1	Step	5 pcs (1 ea)	110-Large Fab - Steps - 1	S220522 / S221200
D3065-041	Step Leg Assembly	5 pcs (1 ea)	180-Large Fab - Steps - 2 - B4B	S217899 / S223665
D3066-1	Spacer	10 pcs (2 ea)	180-Large Fab - Steps - 2 - B4B	8198132
MS20600-AD4W4	Rivet	80 Ea (16 ea)	180-Large Fab - Steps - 2 - B4B	S220750
AN3-35A	Bolt	10 Ea (2 ea) ✓	250-Packaging 1-1 - Pick Kit - B4B	318557 ✓
AN4-13A	Bolt	40 Ea (8 ea) ✓	250-Packaging 1-1 - Pick Kit - B4B	624962 ✓
AN5-36A	Bolt	10 Ea (2 ea) ✓	250-Packaging 1-1 - Pick Kit - B4B	S220750 (6)
D2230-3	Mounting Lug	20 pcs (4 ea)	250-Packaging 1-1 - Pick Kit - B4B	
D2618	Bushing	10 pcs (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	
D2856-400-720	Abrasion Strip 4" X 7.20"	10 pcs (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	
D3235-1	Mounting Lug	10 pcs (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	
D3278-041	Support Assembly	5 pcs (1 ea)	250-Packaging 1-1 - Pick Kit - B4B	
MS21042L3	Nut	10 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	
MS21042L4	Nut	40 Ea (8 ea)	250-Packaging 1-1 - Pick Kit - B4B	
MS21042L5	Nut	10 Ea (2 ea)	250-Packaging 1-1 - Pick Kit - B4B	
NAS1149D0363J	Washer	20 Ea (4 ea)	250-Packaging 1-1 - Pick Kit - B4B	
NAS1149D0463J	Washer	80 Ea (16 ea)	250-Packaging 1-1 - Pick Kit - B4B	
NAS1149D0563J	Washer	20 Ea (4 ea)	250-Packaging 1-1 - Pick Kit - B4B	

#110 - 012408 ✓

#180 - 10498 ✓

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
110-Large Fab - Steps - 1	D3067-1	10	203	0
	D3219-1	10	95	0
	D3272-1	5	10	0
180-Large Fab - Steps - 2 - B4B	D3065-041	5	23	0
	D3066-1	10	257	0
	MS20600-AD4W4	80	1,408	0
250-Packaging 1-1 - Pick Kit - B4B	AN3-35A	10	324	0
	AN4-13A	40	1,260	0
	AN5-36A	10	219	0
	D2230-3	20	648	0
	D2618	10	208	0
	D2856-400-720	10	24	0
	D3235-1	10	287	0
	D3278-041	5	10	0
	MS21042L3	10	685	0
	MS21042L4	40	3,035	0
	MS21042L5	10	387	0
	NAS1149D0363J	20	1,694	0
	NAS1149D0463J	80	4,174	0
	NAS1149D0563J	20	2,029	0
Part Specifications				
Specifications could not be found.				

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Entered: _____

Date: _____

WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Cross tube ☐ Eng. (Non-AW) ☐ Small Fab ☐ Prod. Eng. Coord. ☐ Finishing ☐ Rec/Store/Packaging ☐	Skid-tube ☐ Machining ☐ Large Fab ☐	Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐				
Date : _____		Sequence #: _____		MRB (QS042)				
Description Work Order Deviation		Disposition						
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Preservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY						
		<table style="width:100%; border-collapse: collapse;"> <tr> <td style="width:25%; border-right: 1px solid black;"> Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ </td> <td style="width:25%; border-right: 1px solid black;"> Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Undeclared Instructions ☐ Drill Holes ☐ Fit/Function ☐ </td> <td style="width:25%; border-right: 1px solid black;"> Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ </td> <td style="width:25%;"> Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐ </td> </tr> </table>			Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐	Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Undeclared Instructions ☐ Drill Holes ☐ Fit/Function ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐	Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐
		Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐	Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Undeclared Instructions ☐ Drill Holes ☐ Fit/Function ☐	Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐	Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread ☐			
Other/Details: _____								
Completed By		Lead hand / Supervisor						
		QC / QA Coordinator						

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 as per QSI 004 & Dwg D3272 A/R Aluminum Rod _____ 6-Grind End Plate flush 7-Install last rivet as per Dwg.
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Job BOM

Part / Item	Component Name	Quantity	Operation	Container
D3067-1	End Plate	10 pcs (2 ea)	110-Large Fab - Steps - 1	\$220700
D3219-1	Plate	10 pcs (2 ea)	110-Large Fab - Steps - 1	\$207455
D3272-1	Step	5 pcs (1 ea)	110-Large Fab - Steps - 1	\$21522 / \$2120
D3065-041	Step Leg Assembly	5 pcs (1 ea)	180-Large Fab - Steps - 2 - B4B	\$217599 / \$22665
D3066-1	Spacer	10 pcs (2 ea)	180-Large Fab - Steps - 2 - B4B	\$198132
MS20600-AD4W4	Rivet	80 Ea (16 ea)	180-Large Fab - Steps - 2 - B4B	\$220756
AN3-35A	Bolt	10 Ea (2 ea) ✓	250-Packaging 1-1 - Pick Kit - B4B	\$198557 ✓
AN4-13A	Bolt	40 Ea (8 ea) ✓	250-Packaging 1-1 - Pick Kit - B4B	\$219963 ✓
AN5-36A	Bolt	10 Ea (2 ea) ✓	250-Packaging 1-1 - Pick Kit - B4B	\$20752164 / \$190003(x6)
D2230-3	Mounting Lug	20 pcs (4 ea) ✓	250-Packaging 1-1 - Pick Kit - B4B	\$1874366 / \$153703(x2)
D2618	Bushing	10 pcs (2 ea) ✓	250-Packaging 1-1 - Pick Kit - B4B	\$216173
D2856-400-720	Abrasion Strip 4" X 7.20"	10 pcs (2 ea) ✓	250-Packaging 1-1 - Pick Kit - B4B	\$213173
D3235-1	Mounting Lug	10 pcs (2 ea) ✓	250-Packaging 1-1 - Pick Kit - B4B	\$216668
D3278-041	Support Assembly	5 pcs (1 ea) ✓	250-Packaging 1-1 - Pick Kit - B4B	\$221605
MS21042L3	Nut	10 Ea (2 ea) ✓	250-Packaging 1-1 - Pick Kit - B4B	\$211533
MS21042L4	Nut	40 Ea (8 ea) ✓	250-Packaging 1-1 - Pick Kit - B4B	\$225610
MS21042L5	Nut	10 Ea (2 ea) ✓	250-Packaging 1-1 - Pick Kit - B4B	\$214642
NAS1149D0363J	Washer	20 Ea (4 ea) ✓	250-Packaging 1-1 - Pick Kit - B4B	\$222680
NAS1149D0463J	Washer	80 Ea (16 ea) ✓	250-Packaging 1-1 - Pick Kit - B4B	\$225595
NAS1149D0563J	Washer	20 Ea (4 ea) ✓	250-Packaging 1-1 - Pick Kit - B4B	\$174288

#110 - 012408 ✓

#180 (12498) ✓